

Work Order ID 61939

PRELIMINARY ISSUE

Monday, September 13, 2010 8:17:17 AM

Page 1

Item ID: D4172-3

Accept

Revision ID: PRELIM

Item Name: Support Angle

Start Date: 9/10/2010

Start Qty: 200

Required Date: 9/17/2010

Req'd Qty: 200

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4172

PAR

10.09.16

0.00

100



Small Fab

Memo

0.00

Small Fab

- 1- Cut to length as per dwg
- 2- Use DT9657 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes

10.09.20

①

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 - inspected to P22

Memo

0.00

Dwg only  
10/09/20②  
-3

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=&gt; 10/09/21

Memo

0.00

xl

③

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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|                |               |                 |  |               |       |  |
|----------------|---------------|-----------------|--|---------------|-------|--|
| Item ID:       | D4172-3       | Accept          |  | Setup         | Start |  |
| Revision ID:   | PRELIM        |                 |  |               | Stop  |  |
| Item Name:     | Support Angle |                 |  |               |       |  |
| Start Date:    | 9/10/2010     | Start Qty: 2.00 |  | Cust Item ID: |       |  |
| Required Date: | 9/17/2010     | Req'd Qty: 2.00 |  | Customer:     |       |  |
| Reference:     |               |                 |  |               |       |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br>                        | QC3- Inspect Part Finish                                | 0.00                 |         |        |              | ①             | ②             |                  |                |
| QC<br>Quality Control          | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| 140<br>                        | Identify as per dwg & Stock Location: <u>composites</u> | 0.00                 |         |        |              |               |               |                  |                |
| Packaging<br>Packaging         | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| 150<br>                        | QC21- Final Inspection - Work Order Release             | 0.00                 |         |        |              |               |               |                  |                |
| QC<br>Quality Control          | Memo  | 0.00                 |         |        |              |               |               |                  |                |

RT 10-09-21 (X)

10/09/29

mf

10-9-21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61939



Parent Item: D4172-3



Parent Item Name: Support Angle

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6A1.000W.125               |                        | Purchased     | No          |                     |                  | 100             | f                  | 0.0000         | 6.25        | 13.15789     |               |                |        |
|                                  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| 6061T6 ANGLE 1.00 x 1.00 x .125W |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

M115688

AA 10.09.17

POSITIVE RECALL

EFFECTIVE 10.09.09 AUTH W

RELEASED 10.09.09 DATE 10.09.09

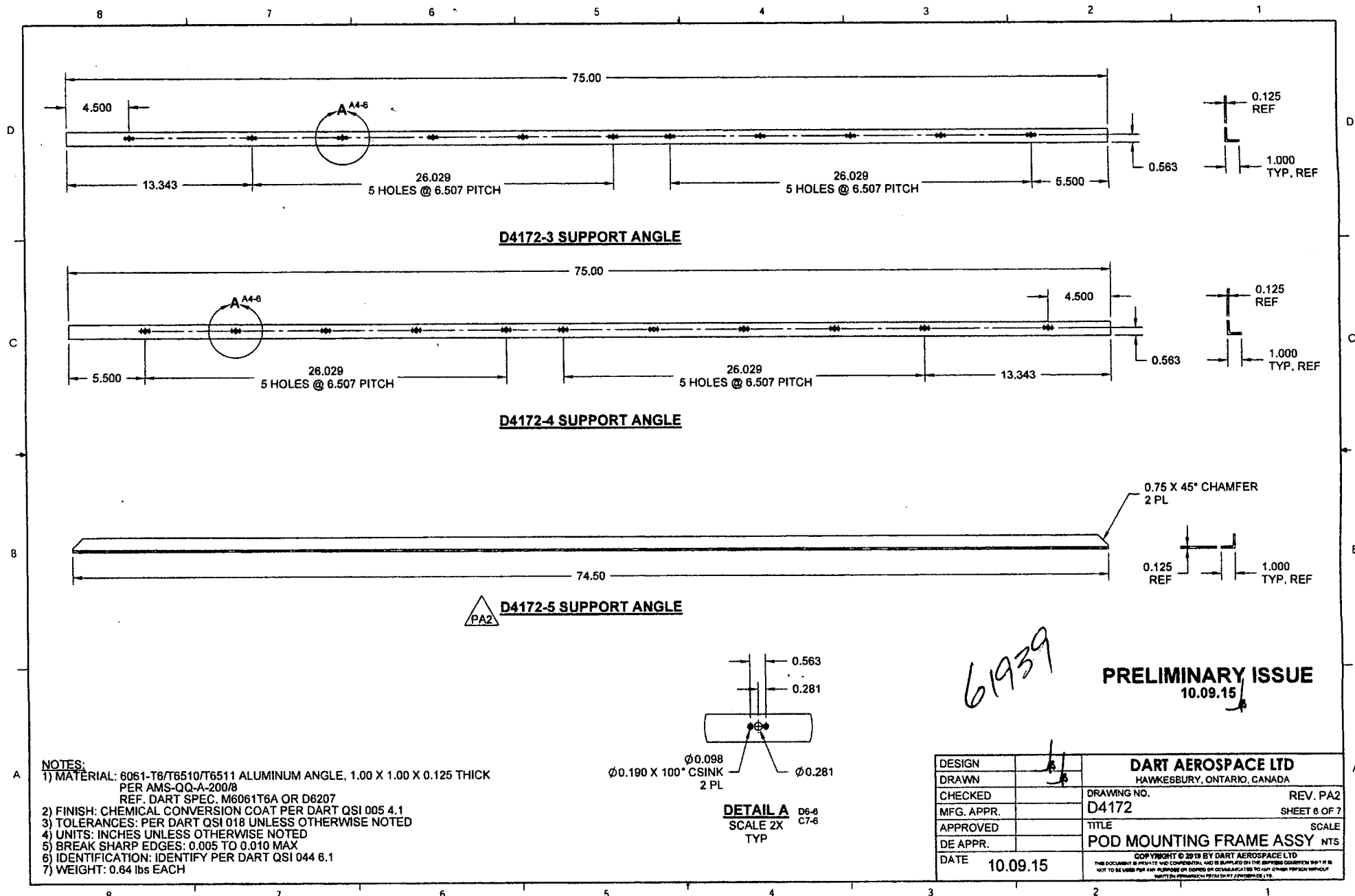
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D4172-3 SUPPORT ANGLE**

**D4172-4 SUPPORT ANGLE**

**D4172-5 SUPPORT ANGLE**

**DETAIL A**  
SCALE 2X  
TYP

- NOTES:**
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK  
PER AMS-QQ-A-200/8  
REF. DART SPEC. M6061T6A OR D6207
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
  - 7) WEIGHT: 0.64 lbs EACH

|            |                 |  |              |
|------------|-----------------|--|--------------|
| DESIGN     |                 | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      |                 | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |                 | DRAWING NO. <b>D4172</b>   | REV. PA2     |
| MFG. APPR. |                 |  | SHEET 6 OF 7 |
| APPROVED   |                 | TITLE  | SCALE        |
| DE APPR.   |                 | <b>POD MOUNTING FRAME ASSY</b>   | NTS          |
| DATE       | <b>10.09.15</b> | <small>COPYRIGHT © 2015 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

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